



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6872882
Job Sheet 197173



Part No: RB6872882

Job Qty: 1 pcs

Part Name: Turbine Front Bearing Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/2/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6872882 Rev. G IPP Rev. A 18.09.17 New issue DP Verify DD/IPP Rev. B 19.06.28 Drawing Revision DP Verify

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	8/9/19	8/9/19	0.00	0.50	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	8/9/19	8/9/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
130	Packaging 3-1 - Stock - B4B	1 pcs	8/9/19	8/9/19	0.00	0.00	QC 5 - 50		DAS AUG 23 2019 40 9-89
							QC 5 - 30		
							QC 5 - 40		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		SA-TBD
							Packaging 3 - 6 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S208342



Part: RB6872882

Job No: 197173

Serial No/Batch: S208342

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 08/23/19

Mon 8-26-2019
Oscar

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

140	QC 21 - FG	1 pcs ✓	8/9/19	0.00 0.00	QC 21 - FG - 21 →	GA-TBD.
Mon 8-26-2019 Oscar					QC 21 - FG - 70	DAS
					QC 21 - SA - 53	70
						9-89

Part Op 100 - Small Fab - Assemble as per drawing. See note 8, 9 and 10.
Descriptions: 110 - QC5- Inspect part completeness to step on W/O
130 - 1- The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG 2-Identify as per dwg & Stock Location:
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98381A511	Dowel Pin 3/16" Dia. 1-1/8" Long	4 pcs (4 ea)	100-Small Fab - 1	S 113333
98381A515	Dowel Pin, Alloy Steel, 3/16" Diameter, 1-3/4" Long	1 Ea (1 ea)	100-Small Fab - 1	S 116648
RB6872882-1	Adjusting Screw	1 pcs (1 ea)	100-Small Fab - 1	S 199376
RB6872882-2	Adjusting Nut	1 pcs (1 ea)	100-Small Fab - 1	S 19975
RB6872882-3	Finger	4 pcs (4 ea)	100-Small Fab - 1	S 198103
RB6872882-5	Ring	1 pcs (1 ea)	100-Small Fab - 1	S 118916
RB6872882-6	Jack Screw	1 pcs (1 ea)	100-Small Fab - 1	S 120243
RB6872882-7	Body Weldment	1 pcs (1 ea)	100-Small Fab - 1	S 200582
RB6872882-9	Handle Weldment	1 pcs (1 ea)	100-Small Fab - 1	S 205327

DAS
71
9-89

AUG 26 2019

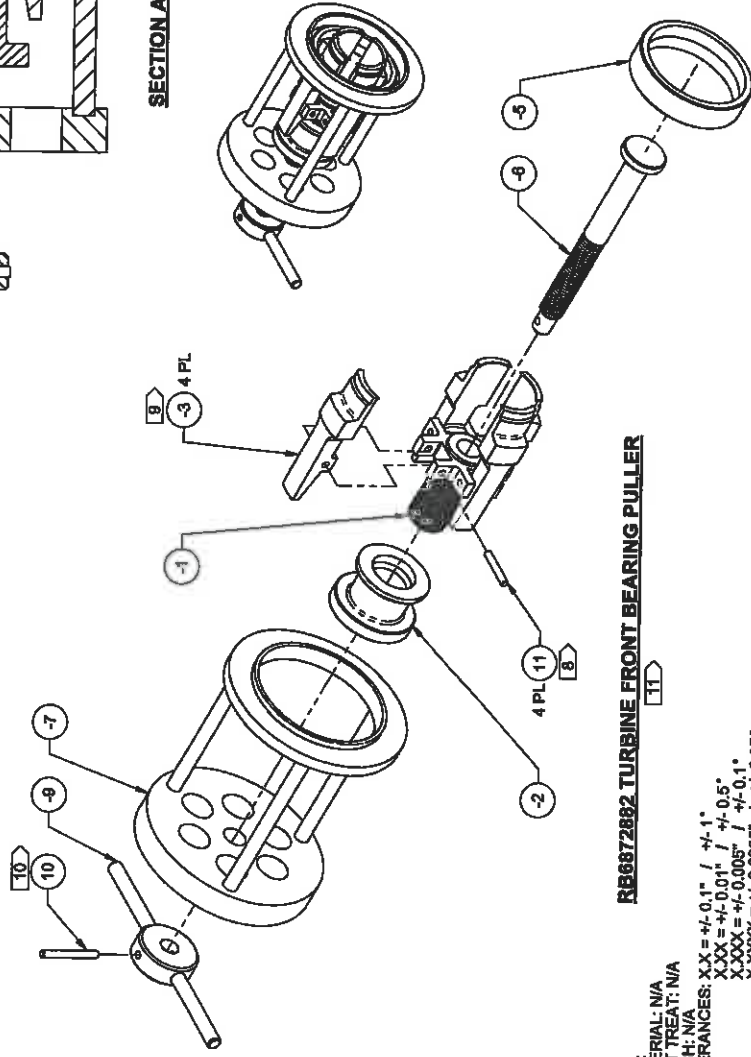
42
140 D 71 13

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	98381A511	4	20	0
	98381A515	1	23	0
	RB6872882-1	1	7	0
	RB6872882-2	1	7	0
	RB6872882-3	4	28	0
	RB6872882-5	1	7	0
	RB6872882-6	1	7	0
	RB6872882-7	1	2	0
	RB6872882-9	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 7/2/19 10:50 AM Dart.lajeunesse.marie

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

ITEM #	QTY	PART #	PART TITLE
-1	1	RB6872882-1	ADJUSTING SCREW
-2	1	RB6872882-2	ADJUSTING NUT
-3	1	RB6872882-3	FINGER
-5	1	RB6872882-5	RING
-6	1	RB6872882-6	JACK SCREW
-7	1	RB6872882-7	BODY WELDMENT
-9	1	RB6872882-9	HANDLE WELDMENT
10	1	McMaster#93381A515 OR EQUIV	STEEL DOWEL PIN 3/16" DIA. X 1-3/4" LG.
11	4	McMaster#93381A511 OR EQUIV	STEEL DOWEL PIN 3/16" DIA. X 1-1/8" LG.

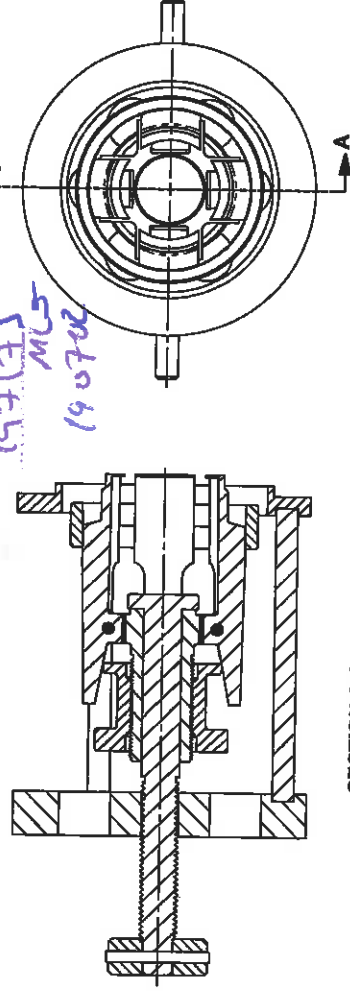


RB6872882 TURBINE FRONT BEARING PULLER

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLY: N/A
8) APPLY RETAINING COMPOUND LOCITE 620 OR EQUIVALENT ON MATING SURFACES
9) THEN PRESS FIT ITEM 11 WITH ITEM 1, AND REMOVE EXCESS
10) ITEM 3 MUST MOVE FREELY BETWEEN SLOTS OF ITEM 1 AND AROUND ITEM 11 DOWEL PIN AS SHOWN
11) THEN PRESS FIT ITEM 10 WITH ITEM 8, AND REMOVE EXCESS
12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



REV.	DESCRIPTION	EON #	BY
1	SEE PREVIOUS FOR Q. 10. REV. 1. TEMPLATE UPDATED PER DART HIST STANDARDS	19-755	VM
2	ITEM 4 REPLACED BY ITEM 11		
3	ITEM 7 REPLACED BY PURCHASE PART ITEM 12		
4	ITEM 4 REPLACED BY PURCHASE PART ITEM 13		
5	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
6	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
7	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
8	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
9	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
10	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
11	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
12	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
13	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
14	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
15	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
16	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
17	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
18	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
19	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
20	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
21	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
22	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
23	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
24	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
25	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
26	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
27	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
28	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
29	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
30	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
31	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
32	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
33	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
34	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
35	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
36	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
37	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
38	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
39	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
40	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
41	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
42	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
43	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
44	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
45	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
46	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
47	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
48	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
49	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
50	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
51	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
52	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
53	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
54	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
55	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
56	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
57	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
58	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
59	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
60	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
61	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
62	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
63	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
64	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
65	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
66	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
67	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
68	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
69	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
70	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
71	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
72	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
73	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
74	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
75	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
76	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
77	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
78	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
79	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
80	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
81	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
82	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
83	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
84	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
85	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
86	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
87	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
88	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
89	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
90	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
91	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
92	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
93	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
94	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
95	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
96	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
97	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
98	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
99	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		
100	ITEM 11 DIMENSION 4X .025 CHANGED FOR 0.025 ± 0.005 4 PL.		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. G
SHEET 1 OF 11

SCALE
NTS

TURBINE FRONT BEARING PULLER

DATE 2019-06-27



CART

AEROSPACE

AEROSPACE

AEROSPACE

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS				Route update only	
Date : _____		Sequence #: _____		QTY Affected : _____		MIRB (QS1042)			
Description Work Order Deviation		Disposition							
						Completed By			
						Lead hand / Supervisor			
						QC / QA Coordinator			
Root Cause		FAULT CATEGORY							
Operator		Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong	
Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Outside Tolerance	
Equip/Tooling		Crushing		BOM/Route		Grain Direction		Drawing	
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Finish	
Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing	
Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Misread	
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up			
Human Factors		Other/Details:							